

Work Order ID 162265

Wednesday, May 31, 2017 9:59:18 AM

162265

Page 1

Item ID: D2282-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle Assembly
 Start Date: 5/31/2017 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 6/20/2017 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: DAS 21 9-89 Date: MAY 31 2017 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2282	Rev E								
100	Large Fab	0.00							
100									
Large Fab	Memo	2.00							
Large Fab	1-Weld as per D2282-043 Saddle Assembly A/RER316L SS Filling Rod <u>M136585</u> Dwg Rev: <u>E</u>								
110	Small Fab	0.00							
110									
Small Fab	Memo	0.39							
Small Fab	1- Grind weld with rough pad and brown pad, take all welding marks out and deburr holes***DO NOT TAKE RED AND BLUE PAD TO BUFF PART***								
120	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
120									
QC	Memo	0.20							
Quality Control									

10 Q.L 17-06-06

10 Q.L 17-06-06

10 1206-07 DAS 9 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																							
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :	
Misidentified ☐	Past Due ☐																																																														

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab Small Fab	Memo 1 - Tumble DAS 9 9-89	0.00 1.00							
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.20				(16)	17-06-07		DAS 19 9-89
160 *160* Packaging Packaging	Identify as per dwg & Stock Location: <u>GA</u> Memo LOCATION : GA	0.00 0.20				10	10	JUN 07 2017	DAS 19 9-89

DQA: _____ Date: _____



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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Page 3

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N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Saddle Assembly

Start Date: 5/31/2017 Start Qty: 10.00

10

Cust Item ID:

Required Date: 6/20/2017 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

1.00

Quality Control

JUN 07 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Misidentified ☐	Past Due ☐																																																														

Picklist Print

Wednesday, May 31, 2017 9:59:21 AM

Page 1

Work Order ID: 162265

162265

Parent Item: D2282-043

D2282-043

Parent Item Name: Saddle Assembly

Start Date: 5/31/2017

Required Date: 6/20/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2281

Manufactured No

100

Each

55.0000

1

10

D2281

**

Q.V 17-06-06

Jack Saddle

Location

Loc Qty

Loc Code

WA001

55

150910

0

160570

55

10

D2282-7

Manufactured No

100

Each

95.0000

2

20

D2282-7

**

Q.V 17-06-06

Tube

Location

Loc Qty

Loc Code

WA001

95

160573

95

20

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



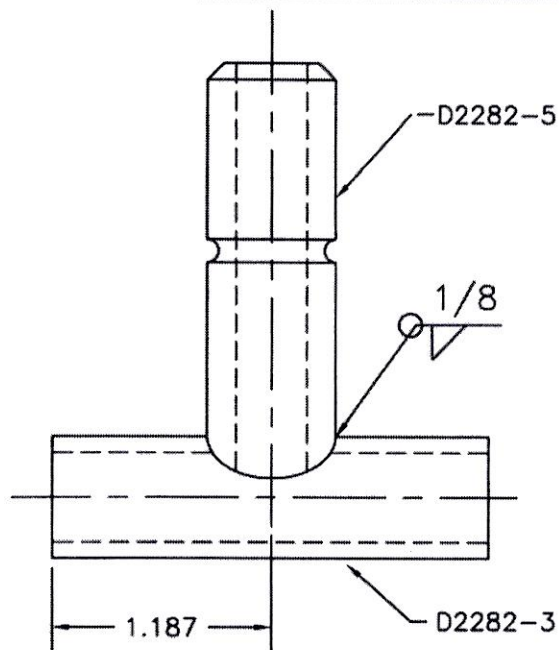
QA Closed: _____ Date: _____

Work Order update only ☐

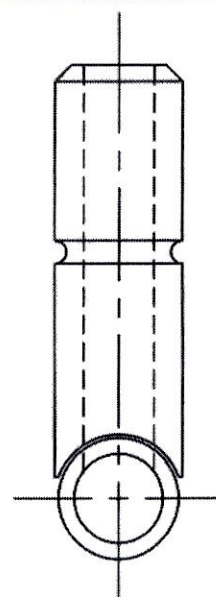
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Misidentified ☐	Past Due ☐																																																																



DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>UP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1

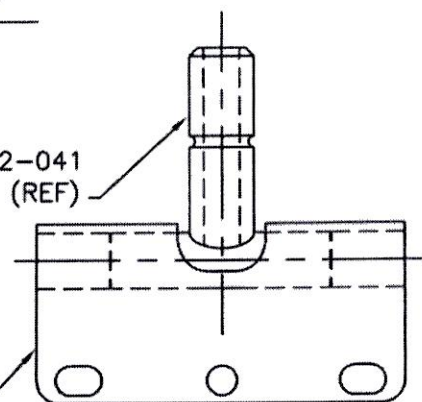


D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

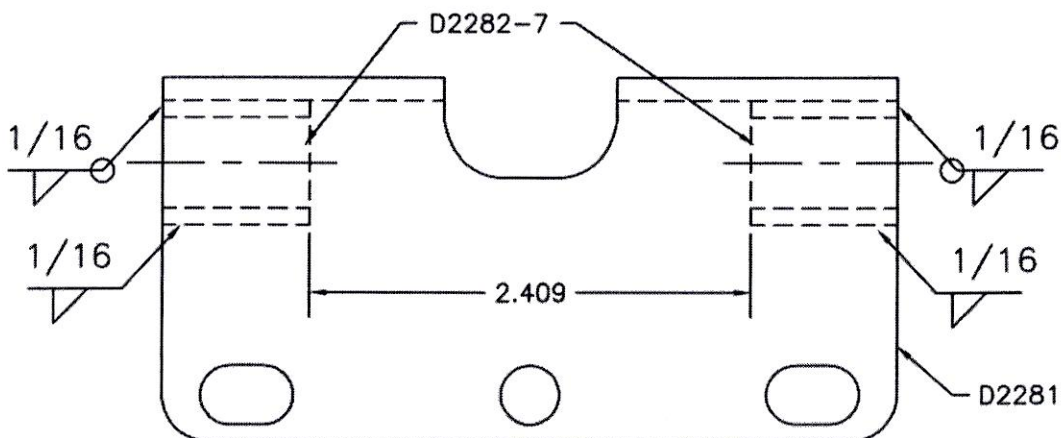


D2282-041
(REF)

D2282-043
(REF)



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

RELEASED
[Signature]
05/09/16

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 102265
1053/

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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